

52

Date: Wednesday, 11/28/2007 2:23:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 36012		
Estimate Number	: 10323		
P.O. Number	:	Part Number	: D206559013
This Issue	: 11/28/2007 S.O. No. :	Drawing Number	: D2432 REV F3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: F3
Previous Run	: 32768	Material	:
Written By	:	Due Date	: 12/23/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>Kim Johnston 11.28</u>		
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

Per attached

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.8250 sf(s)/Unit Total : 27.3000 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: M106717 DJP 08/01/15

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

DJP 08/01/15

④

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 08/01/15

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/28/2007 2:23:03 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36012

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/01/18

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

1334777

scf

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

1332857

36612

scf

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

1332016

scf

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer

1335356

8/1/18 scf

(4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36012

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2732

Rubber Extrusion



10.4

Comment: Qty.: ~~10.4~~ 11.0 f(s)/Unit Total: ~~4.6664~~ 4.6664 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B34117

SP

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M104746

(44X)

M103585

SP

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M103691

SP

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M105906

SP

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M105054

8/1/18 SP (4X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Wednesday, 11/28/2007 2:23:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 36012

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2008/01/18

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: A

8/1/18 SC (4X)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008.01.21

Job Completion



2008/11/21

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36012
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055 x 45°	✓			
B	5.500	+/-0.030	5.503	✓			
C	0.200	+/-0.030	0.190	✓			
D	0.25 x 45°	+/-0.030	0.25 x 45°	✓			
E	R0.250	+/-0.030	0.250	✓			
F	0.250	+/-0.010	0.258	✓			
G	0.625	+/-0.030	0.630	✓			
H	0.375	+/-0.010	0.385	✓			
I	0.950	+0.030/0.010	0.962	✓			
J	19.000	+/-0.030	19.	✓			
K	3.14	+/-0.030	3.14	✓			
L	3.28	+/-0.030	3.28	✓			
M	Ø0.260	+0.005/-0.000	0.260	✓			
N	Ø0.93	+/-0.030	0.929	✓			
O	0.30	+0.030/-0.000	0.315	✓			
P	23.750	+/-0.030	23.75	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	1.990	✓			
T	9.000	+/-0.010	9.0	✓			
U	9.000	+/-0.010	9.0	✓			
V	0.375	+/-0.010	0.378	✓			

Measured by:	DJP
Date:	08/01/15

Audited by:	[Signature]
Date:	08-01-15

Prototype Approval:	N/A
Date:	N/A.

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF [Signature]	[Signature]

Copyright 1995 by DART AEROSPACE LTD

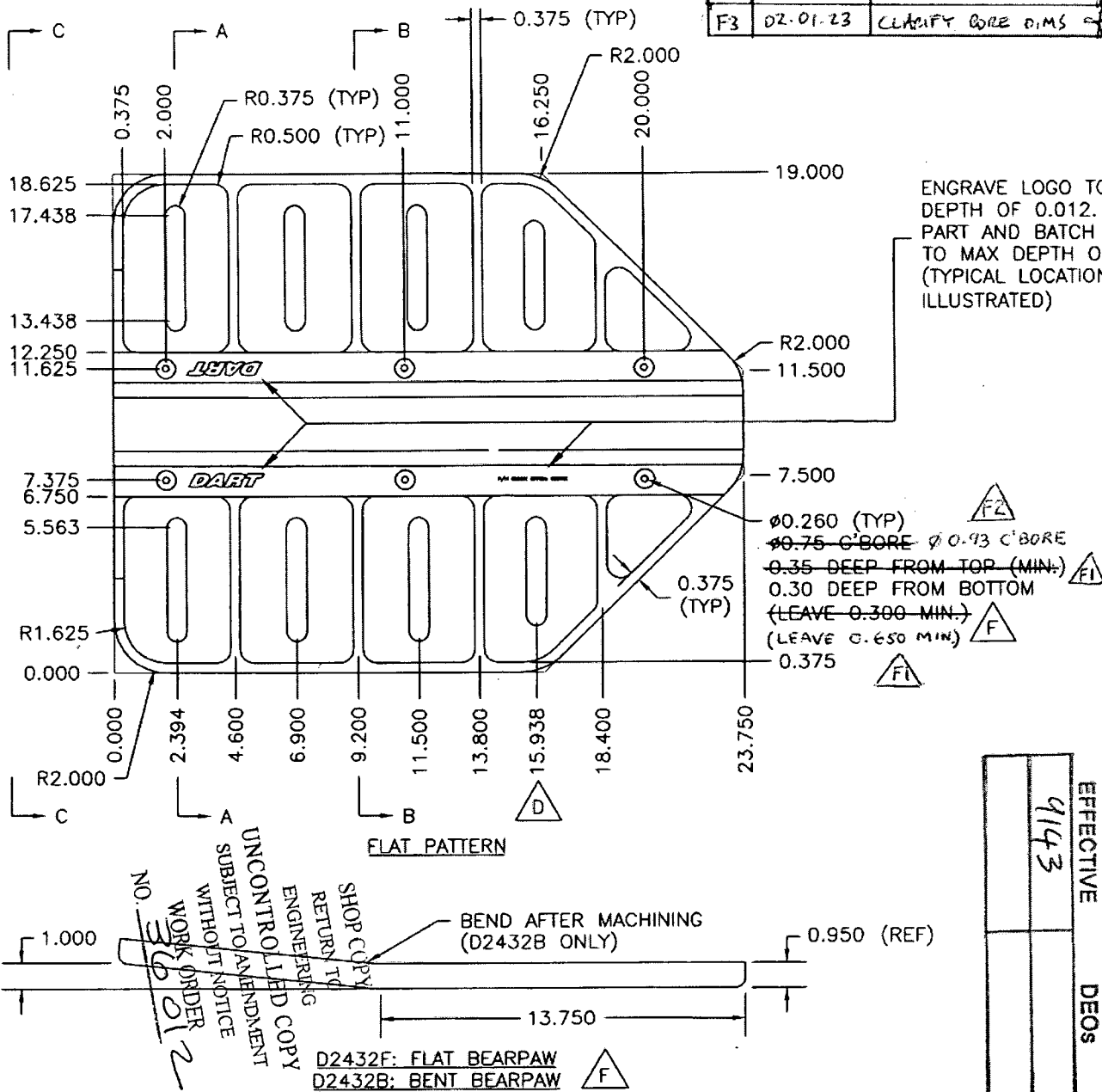
F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
93-06-17 KE

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F SHEET 1 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

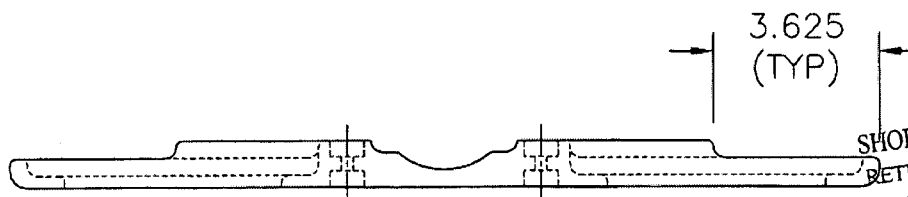
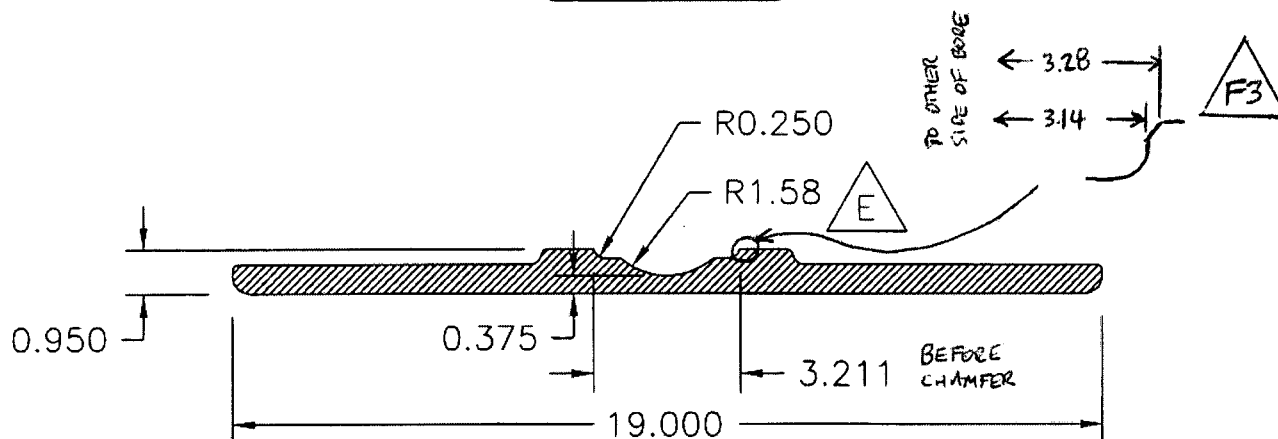
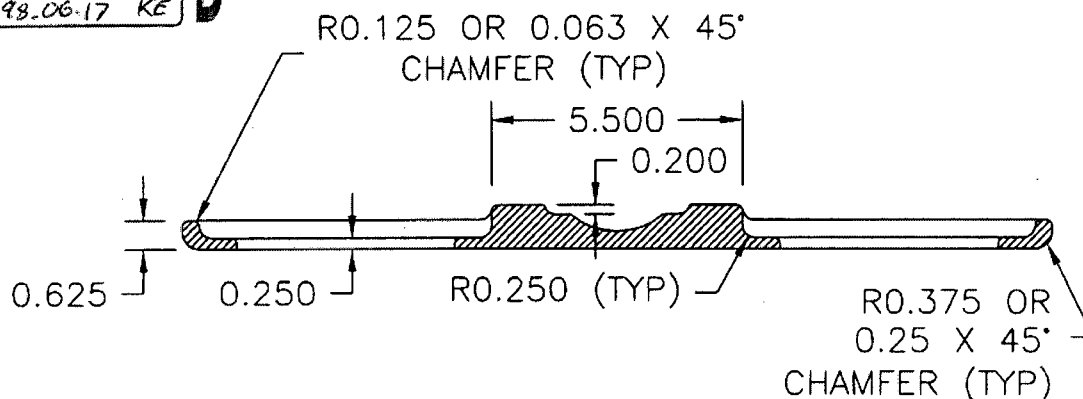


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36012

52

Date: 11/28/2007 2:23:03 PM
User: Kim Johnston

Process Sheet

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Estimate Number : 10323
P.O. Number : Part Number : D206559013
This Issue : 11/28/2007 S.O. No. : Drawing Number : D2432 REV F3
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : MACHINED PARTS Drawing Revision : F3
Previous Run : 32768 Material :
Written By : Due Date : 12/23/2007 Qty: 4 Um: Each
Checked & Approved By : Kim Johnston
Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM
Est Rev:K 07-01-02 Was K10008 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 27.3000 sf(s)
blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
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(MUHMWB10)
Batch: _____

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Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE